



Dart Hawkesbury
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D4634-143
Job Sheet 167077-A



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	2017-12-14
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	17/12/18
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	17/12/18
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	DEL 21
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	0.11.17-12-27
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 138649 Expiry Date 10/01/29 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	-D4634-3 5021628	1	2	0	0
	5021879 -D4636-5 F16451A	2	43	0	0
	-D4647-1 F165218	1	4	0	0
	-D4664-5 5021625	6	39	0	0
	-D4712-1 5021624	2	4	0	0
	-D4732-21 5021623	1	6	0	0
	-D4732-25 5021622	1	7	0	0
	-D5021-3 5021621	1	2	0	0
	-MPNY-750S-9-C 5021620	3	570	0	0
	↑ -MS20426AD3-4 5021619	4	5,055	0	0
	↑ -MS20426AD4-6 5021617	4	2,797	0	0
	-MS21059L08 5021618	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Mfg Date: 12/14/17 Job No: 167077 - A		AGAINST DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐	
		QTY Effective : _____				MRB (QSI042) Approval			
		Disposition				Completed By			
						Lead hand / Supervisor Approval Verification			
						QC / QA Coordinator Approval			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		DART AEROSPACE S021891				Middle, Center Ceiling Replacement Panel Assembly D4634 - 143 Start up Operation		FAULT CATEGORY	
		PART NO: Revision: Operation: Change No:		Temperature/Cure ☐ Set-up ☐ DM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Wave/Twist in Tube ☐ Marks/Chatter ☐		OTHER : _____			